

Work Order ID 61205

Wednesday, August 11, 2010 10:13:18 AM



Page 1

Item ID:	D3066-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Spacer					
Start Date:	8/11/2010	Start Qty:	40.00		Cust Item ID:	
Required Date:	8/25/2010	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MUF</u>	Date:	<u>10-8-11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3066	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3066								
<u>6061 .080</u>	Dwg Rev: <u>5</u>								
	Prog Rev: <u>5</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

10-8-24

(48)

10-8-24

10/08/25

(48)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3066-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 8/11/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Memo

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

= 7/11

10/03/25

48

0

140



QC

Memo

Quality Control

QC3- Inspect Part Finish

0.00

0.00

m

10

08

25

48

150



Packaging

Memo

Packaging

Identify as per dwg & Stock Location: PAT

WA

0.00

0.00

*** STOCK IN STEP CELL***

10/03/25

480

W/O:		WORK ORDER CHANGES					
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Item ID: D3066-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer

Start Date: 8/11/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/08/26
mf
10-8-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Wednesday, August 11, 2010 10:13:17 AM

Page 1

Work Order ID: 61205



Parent Item: D3066-1



Parent Item Name: Spacer

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐ C ☐ 02.11.01 ☐ Incorporated D3066-1 IPP ☐ KJ/RF
IPP Rev: B Now M6061-T6 06-06-23 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

48.3512

0.0945

3.978947

4.6



1810-8-24

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT21

48.3512

113438

0.3512

115389

48

115389

48

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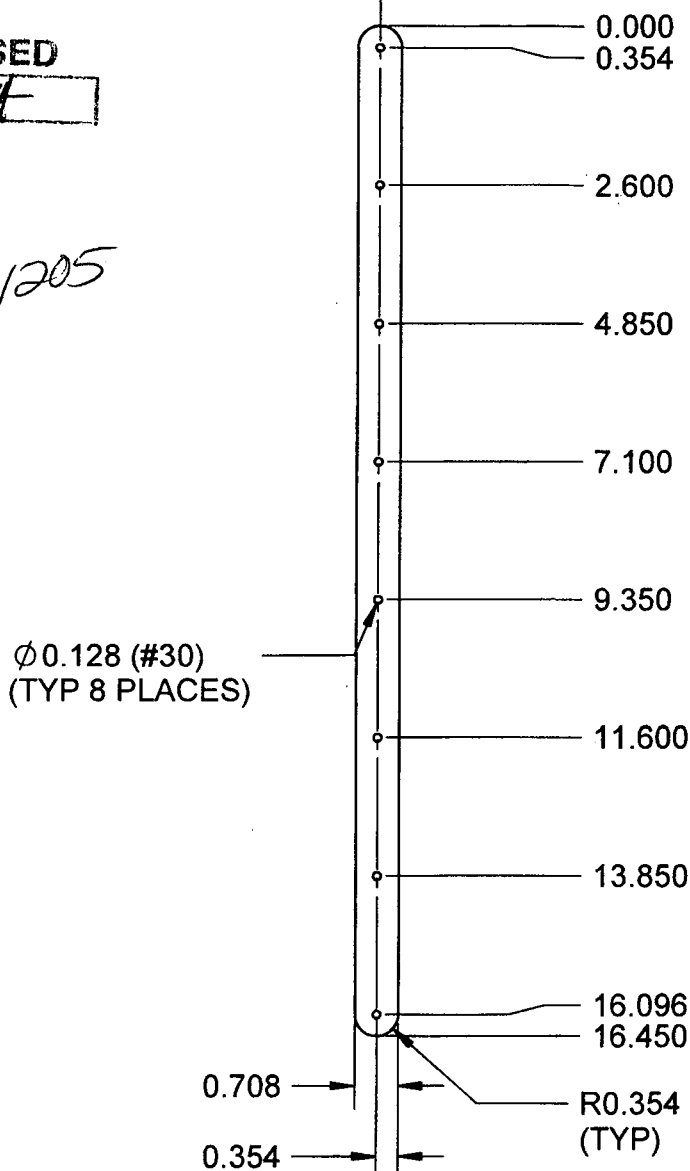
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED
de. de. 20 *[Signature]*

6/205



D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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